DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-020458
Date Inspected: 02-Feb-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Qiu Wen

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Orthotropic Box Girder(OBG)

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

Bay 14

WELDING:

Segment 14W

This QA Inspector observed ZPMC qualified welding personnel identified as 067888 perform Flux Cored Arc Welding (FCAW), weld joint identified as DP3171-001-077; located On Orthotropic Box Girder (OBG) Deck Plate to Deck Panel diaphragm CJP Weld; ABF Quality Assurance (QA) is identified as Mr. Shen Jian Yuan. This QA Inspector observed a welding current of approximately 240 amps and 26 volts and the base material appears to have been being preheated by an electrical heating elements prior to welding. ABF Quality Assurance (QA) Mr. Shao Jian Yuan was onsite monitoring the welding variables. The welding variables recorded by QA appeared to comply with applicable WPS-B-T-2233-ESAB. See attached photo for further details.

This QA Inspector observed ZPMC qualified welding personnel identified as 067707 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP3174-001-035; located On Orthotropic Box Girder (OBG) Deck Panel to Stiffener CJP Weld; ABF Quality Assurance (QA) Mr. Shao Jian Yuan was onsite monitoring the welding variables. The welding variables recorded by QA appeared to comply with applicable WPS-B-P-2212-TC-U4b-FCM.1. See attached photo for further details.

This QA Inspector observed ZPMC qualified welding personnel identified as 066239 perform Flux Cored Arc Welding (FCAW), weld joint identified as DP3171-001-142; located On Orthotropic Box Girder (OBG) Deck Plate to Deck Panel diaphragm CJP Weld; ABF Quality Assurance (QA) is identified as Mr. Shen Jian Yuan. This QA Inspector observed a welding current of approximately 270 amps and 25.2 volts and the base material appears to have been being preheated by an electrical heating elements prior to welding. ABF Quality Assurance (QA) Mr. Shao Jian Yuan was onsite monitoring the welding variables. The welding variables recorded by QA appeared to comply with applicable WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 066038 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3020E-052; located On Orthotropic Box Girder (OBG) Bottom Plate to floor Beam CJP Weld; The Critical Welding Repair Report (CWRR) was B-WR2734 This QA Inspector observed a welding current of approximately 236 amps and 24.8 volts and the base material appears to have been being preheated by an electrical heating elements prior to welding. ABF Quality Assurance (QA) Mr. Wang Jiang Hua was onsite monitoring the welding variables. The welding variables recorded by QA appeared to comply with applicable WPS-345-SMAW-2G (2F) FCM-Repair-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067765 perform Flux Cored Arc Welding (FCAW), weld joint identified as SEG3020F-073; located On Orthotropic Box Girder (OBG) FB3337A to LD3050A CJP Weld; ABF Quality Assurance (QA) is identified as Mr. Shen Jian Yuan. This QA Inspector observed a welding current of approximately 282 amps and 23.6 volts and the base material appears to have been being preheated by an electrical heating elements prior to welding. ABF Quality Assurance (QA) Mr. Wang Jiang Hua was onsite monitoring the welding variables. The welding variables recorded by QA appeared to comply with applicable WPS-B-T-2231-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 069493 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP3174-001-037; located On Orthotropic Box Girder (OBG) Deck Panel to Stiffener CJP Weld; ABF Quality Assurance (QA) Mr. Shao Jian Yuan was onsite monitoring the welding variables. The welding variables recorded by QA appeared to comply with applicable WPS-B-P-2212-TC-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 037779 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP3172-001-036; located On Orthotropic Box Girder (OBG) Deck Panel to Stiffener PJP Weld; ABF Quality Assurance (QA) Mr. Shao Jian Yuan was onsite monitoring the welding variables. The welding variables recorded by QA appeared to comply with applicable WPS-B-P-2212-TC-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067904 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP3172-001-037; located On Orthotropic Box Girder (OBG) Deck

Panel to Stiffener CJP Weld; ABF Quality Assurance (QA) Mr. Shao Jian Yuan was onsite monitoring the welding variables. The welding variables recorded by QA appeared to comply with applicable WPS-B-P-2212-TC-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer